

Work Order ID 69177

Wednesday, May 04, 2011 8:34:56 AM



Page 1

Item ID:	D2731-7	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Lug				Stop	
Start Date:	5/4/2011	Start Qty:	36.00			
Required Date:	5/13/2011	Req'd Qty:	36.00			
Reference:						

Paint blue

Approvals:	Process Plan:	<i>CL</i>	Date:	<i>11/05/04</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2731	Rev C

100	BAND SAW	0.00							
Bandsaw	Memo	0.00							<i>CL 11/05/04 36</i>
Jeaspa Bandsaw	Cut D2423 extrusion to .82"	Batch							
	<i>Cut @ meter</i>								

110	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							<i>CL 11/05/04 36</i>
HAAS CNC vertical machine #1	1-Machine as per folio FA930								
	DWG REV:								
	FOLIO REV:								
	<i>issue 710 to meter</i>								
	2-Check for crack while loading into the machine								

PRO: 18001

Machine as per drawing D2731-7 REV.C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2731-7

Accept

Setup Start

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Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 36.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

~~QC2~~ Inspect parts off machine FAI/FAIB

0.00

QC rec'd
Quality Control

Memo

0.00

rec'd + inspect for transit damage
attached c/c to W10

CL 11/05/04 36

P4110/17 (36)

130

QC6 Inspect parts - second check

0.00

QC
Quality Control

Memo

0.00

S 4/15/19

wants
(x36)

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish
Hand Finishing

Memo

0.00

x36 d 11/05/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Revision ID:

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Item Name: Mounting Lug

Start Date: 5/4/2011 Start Qty: 36.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 36.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Powdercoat

Powder Coating

White Glue (Ref: 4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: _____

FINISH TIME: _____

OVEN TEMPERATURE: _____

Primer 117319

paint 115985

clean 117101

11-05-25 x36

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11-05-26 x36

170



Packaging

Packaging

Identify as per dwg & Stock Location: 400

0.00

Memo

0.00

11/26 SP 36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 36.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/309J

W640526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 8:34:52 AM

Page 1

Work Order ID: 69177

Parent Item: D2731-7

Parent Item Name: Mounting Lug





Start Date: 5/4/2011

Required Date: 5/13/2011

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP ☐ D ☐ 00.05.19 ☐ Added inspect level 8, removed P/O powder coating ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P 		Purchased	No			100	Each	0.0000	1	36			
LUG D2423 		Manufactured	No			110	f	342.8400	0.0683	2.588211			
Lug Extrusion													

6/10/11 (36)

CL 1/10/04

Location

Loc Qty

Loc Code

MAT006

342.84

43722

161.5

45800

1

63005

180.34

2.59

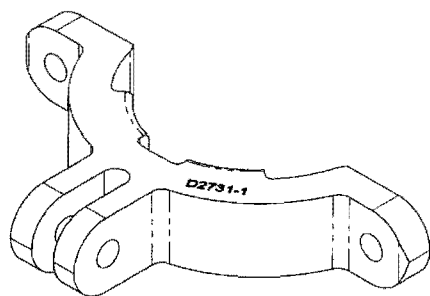
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

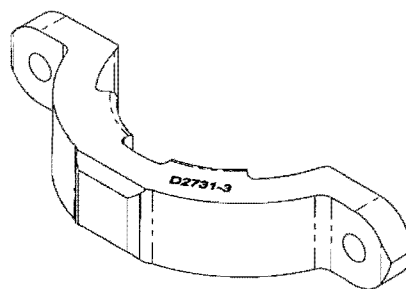
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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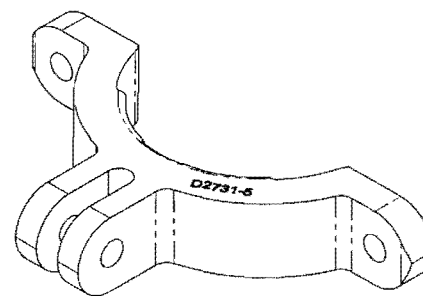
NOTE: Date & initial all entries



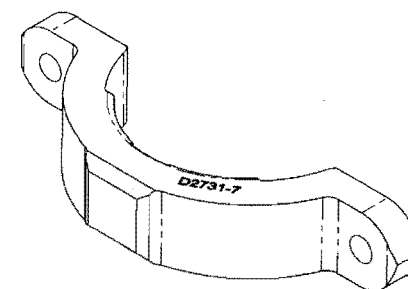
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

C211105104

W10: 69177

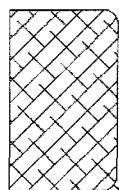
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

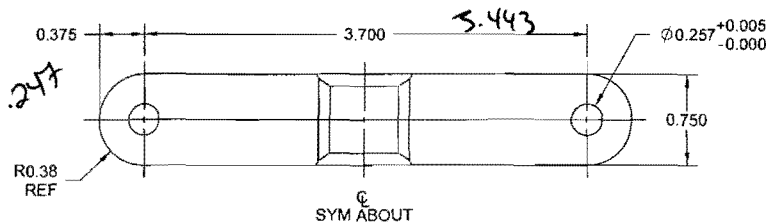
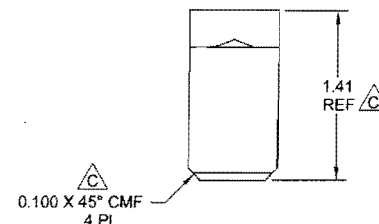
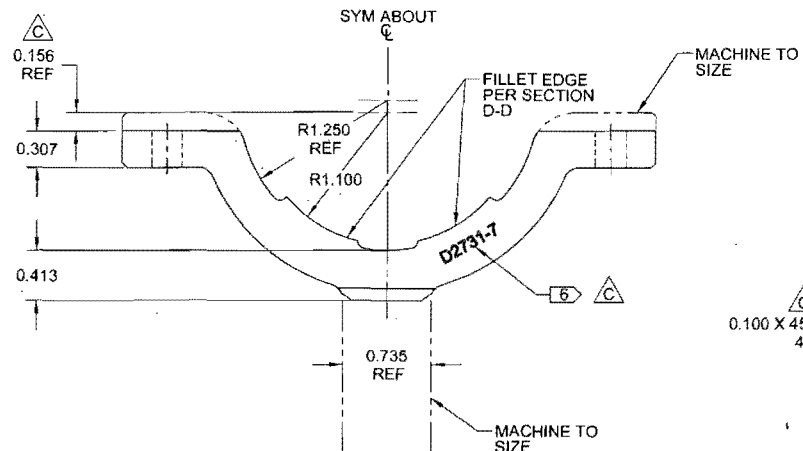
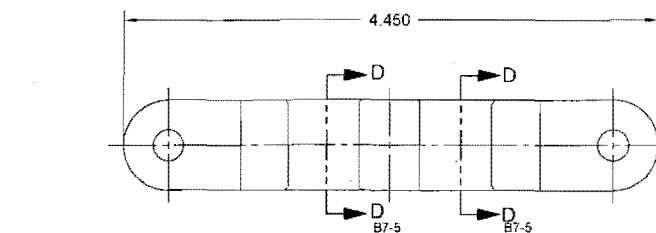
RELEASED
09/01/19

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2731 REV. C SHEET 1 OF 5 TITLE MOUNTING LUG SCALE NTS <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.19		

SECTION D-D
SCALE 2X







R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

RELEASED
09/06/25

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2731	SHEET 5 OF
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NT
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14001

Purchase Order Date 5/4/2011

PO Print Date 5/4/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
C/L Hostley

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	Vendor Part Number						
1	D2731-7P	LUG	5/13/2011 Yes	36.00 Each	Dart Truck	\$13.9000	\$500.40
		Special Inst:	MACHINE AS PER DWG D2731 REV. C B69177				
2	D3394-3P	Lug	5/13/2011 Yes	36.00 Each	Dart Truck	\$18.9500	\$682.20
		Special Inst:	MACHINE AS PER DWG D3394 REV. B B69180				
3	D2230-1P	LUG	5/13/2011 Yes	100.00 Each	Dart Truck	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B69179				

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

PO Total:

\$3,077.60

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 5/4/2011

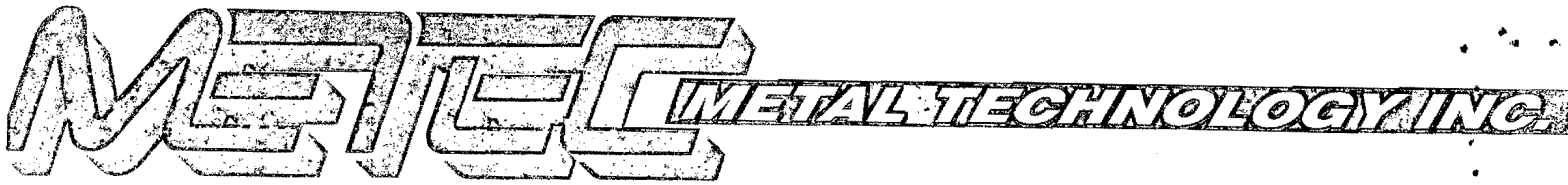


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17970
Date: May 16, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14001	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 Lug Material supplied by DART: D2423 B63005	Each	36	36	
D3394-3 Lug Material supplied by DART: D2423 B63005	Each	36	36	
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		100
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____	Thank you for your order!			



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
36	D2731-7P	Lug <i>5 11/15-1/2</i>	14001
36	D3394-3P	Lug	14001

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 16, 2011

